

Work Order ID 135957

Tuesday, August 25, 2015 1:07:25 PM

135957

Page 1

Item ID: D6101-003 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet, 7075
Start Date: 8/25/2015 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 8/25/2015 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: MLS Date: AUG 25 2015 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6101	Rev B								

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 29612

a) Description: Aluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

0.00

0.00

CH

AUG 26 2015

40

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material certification is attached

0.00

0.00

40
SEP 14 2015

DAS

06
SEP 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

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135957

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				40	0		DAS 14 9-89 15/09/15
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: MAT045	0.00				40	0		DAS 14 9-89 15/09/15
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT044								
140	QC21- Final Inspection - Work Order Release	0.00							SEP 15 2015
140									
QC	Memo	0.00							
Quality Control									

20150915

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Tuesday, August 25, 2015 1:07:28 PM

Page 1

Work Order ID: 135957

135957

Parent Item: D6101-003

D6101-003

Parent Item Name: Saddle Billet, 7075

Start Date: 8/25/2015

Required Date: 8/25/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A: 01.05.04New IssueC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P		Purchased		No		110	Each	0.0000	1	40			
D6101-003P										**			
7075-T7351 2X6.25X7.875													

SEP 14 2015

DAG
06
000

DQA: _____ Date: _____



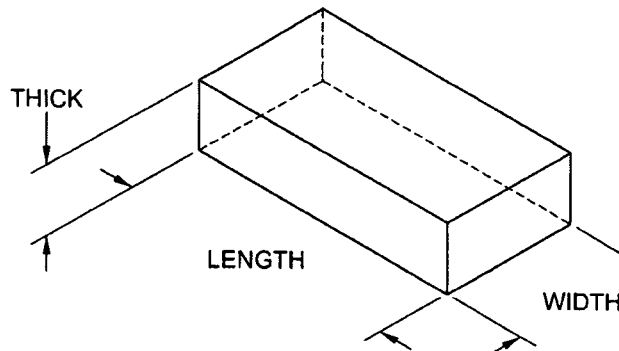
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : _____					

SPECIFICATION CONTROL DRAWING



135957 M.C.S
15-08-25

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W3

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29612**

Purchase Order Date 8/26/2015

PO Print Date 8/26/2015

Page Number 1 of 3

Order From :

VU-MET002

Ship To : DART AEROSPACE LTD

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	D6101-001P	7075-T7351 2X6X6.25	9/14/2015 Yes 9/14/2015		40.00 Each	\$32.25	\$1,290.00
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AS PER DWG D6101 REV. B
B135956
SIZE: 6.00" X 6.250" X 2.00" THICK
GRAIN DIRECTION ALONG 6.00" LENGHT
MATERIAL: 7075-T7351 QQ-A-250/12
TOLERANCE AS PER QUOTE +.030"/-.000"

Line Total: \$1,290.00

2	D6101-003P	7075-T7351 2X6.25X7.875	9/14/2015 Yes 9/14/2015		40.00 Each	\$39.45	\$1,578.00
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AS PER DWG D6101 REV. B
B135957
SIZE: 7.875" X 6.250" X 2.00" THICK
GRAIN DIRECTION ALONG 7.875" LENGHT
MATERIAL: 7075-T7351 QQ-A-250/12
TOLERANCE AS PER QUOTE +.030"/-.000"

10/19/14
SCL

Note:

8/26/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO29612

Purchase Order Date 8/26/2015
PO Print Date 8/26/2015

Page Number 2 of 3

Order From :
METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Line Total: \$1,578.00

3 D6103-003P Round Alum Billet 9/14/2015
Yes
9/14/2015

12.00

Each

\$59.68

\$716.19

AS PER DWG D6103 REV. B
B135958
MATERIAL: 7075-T7351 AS PER QQ-A-225/9
SIZE: 3.500" X 12.500" LONG

Line Total: \$716.19

4 D6104-003P 17-4 SS Roundbar 3.25"Od 9/14/2015
Yes
9/14/2015

12.00

Each

\$36.25

\$435.00

AS PER DWG D6104 REV. B
B135959
SIZE: 3.25" X 3.80" LONG
MATERIAL: 17-4 PH AS PER AMS 5643 OR AISI 630

Line Total: \$435.00

Note:

8/26/2015

**Castle Metals®**

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 2

Shipment No:2723025

Ship From: A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 11-SEP-2015	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2723025-2	

Shipment Details	Final Destination Branch - MON
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Order No 4037558	Line No 2	Item No 752237.MO	Description (2.0000.PL.7075.T7351) ALUMINUM.US1.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No 29612		Part Number YOUR ITEM NUMBER: D6101-003		Ordered Qty 40.00 PCS		Invoice Qty 40.00 PCS	
Details		SHIP TO CASTLE, MONTREAL (POINTE-CLAIRE) CUSTOMS BROKER: GEORGE H. YOUNG END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS 15/9/14					
Delivery No. 120164595	Mill KAISER ALUMINUM	Heat Number 	Mech Id	PCS 40	Width (IN)	Length (IN)	Shipped Qty(LBS) 406.4338

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 11-SEP-2015 08:56:45 AM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

Reviewed by Authorized Castle Metals Representative:

Date:

Name:



11 SEP. 2015

SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number
4386614

7/8

CUSTOMER PO NUMBER: 325758		WORK PACKAGE:		CUSTOMER PART NUMBER: 752237		SHIP RUN/LOAD: 103293/4		GOVT CONTRACT NUMBER:		
KAISER ORDER NO: 1189745		LINE ITEM: 1	SHIP DATE: 13-AUG-2015	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: KaiserSelect Plate			
WEIGHT SHIPPED: 2874 LB		QUANTITY: 2 PCS EST.		TRUCK B/L #: 2055458		GAUGE: 2.0000 IN (50.8000 MM)		DIAMETER/WIDTH: 48.500 IN (1231.9 MM)		LENGTH: 144.500 IN (3670.3 MM)

MHU 1920113: LOT 778408A5: 2 pieces;

Certified Specifications

AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
MMS 159/RevT

AMS-00-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevU
GAMPS 9101/RevB/AmdSCN1
PS 21211/RevM

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 008/RevE
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 778408A5 Cast 850 Drop 19 Ingot 5 Parent Lot: 141903B5 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temp: T7351	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 72.2 : 74.9 (498 : 516)	Yield KSI (MPA) 61.3 : 65.0 (423 : 448)	Elongation % 12.2 : 12.6
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(ASTM E1004)
(EN 2004-1)

Conductivity, %IACS :	39.2 Min	39.3 Max
(MS/M) :	22.7 Min	22.8 Max



(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.09	0.19	1.4	0.05	2.6	0.20	5.5	0.02	0.01	0.01	TOT 0.05

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4386614

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413A R 7
AMS 4078, AMS QQ-A-250/12, AMS STD-2154, A
STM 8209, ASTM B594, BS
S 7055, CMMP 025, CSTI 006, DPS 4.713, GAMP
S 9101, MMS 159, PS 212

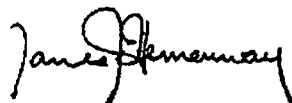
11

TEST NOTES

Metal represented by this test report was 100% immersion
ultrasonically tested from one side with 3mm dead zones top
and bottom and meets the Class A and Class B requirements of
all specifications referenced on this test report. No
surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO-9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:
* has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
* was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
* has been thermally processed in compliance with AMS 2772, where applicable.
* is mercury free, within the limits of detection of ASTM E1251 (< = 1 ppm).
* is in compliance with RoHS 2, European Union Directive 2011/65/EU.
* is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2008.
* is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on this certificate may be punished as a felony under federal law.



JAMES HEMENWAY, LABORATORIES SUPERVISOR

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-003
 DATE: 15/09/15

PO / BATCH NO. 29612/135957

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 40
 QUANTITY INSPECTED: 40
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 7.875X6.250X2.00
 THICKNESS RECEIVED: 7.875X6.250X2.00
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL	☒	N	
CORRECT THICKNESS	☒	N	
PHOTO REQUIRED	Y	☒	
CORRECT MATERIAL	☒	N	
CORRECT REF # TO LINK CERT	☒	N	
CORRECT MATERIAL IDENTIFICATION	☒	N	
CORRECT M# ON THE MATERIAL	☒	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>14</u> DATE: <u>15/09/15</u>	SIGNED OFF BY: _____ DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2, ...) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER